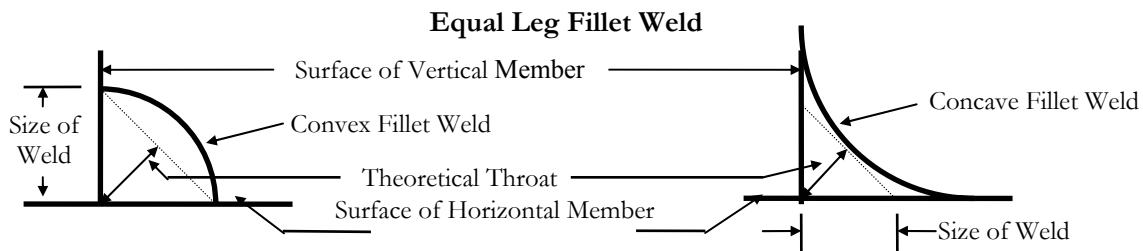


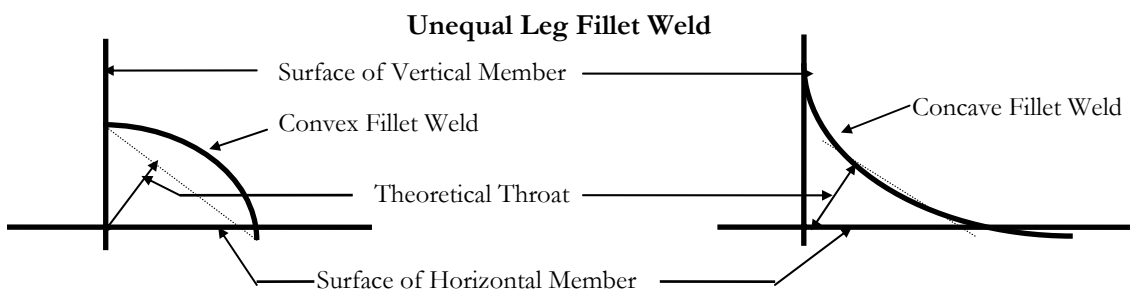
Section WFP 2-15 – Welding Fabrication Procedure
Attachment 2, Fillet Weld and Socket Weld Profiles

Rev. 0, 8/16/04

FILLET WELD AND SOCKET WELD PROFILES

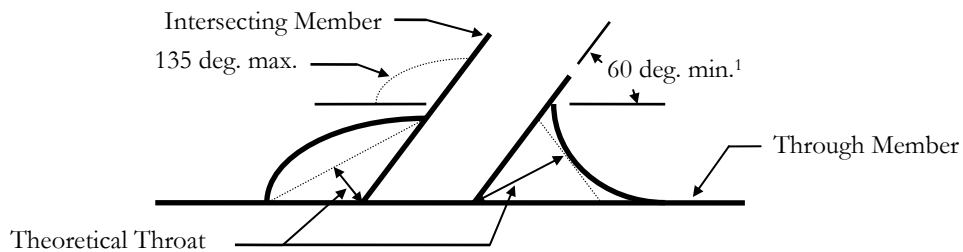


The size of an equal leg fillet weld is the leg length of the largest inscribed right isosceles triangle.
Theoretical Throat = 0.7 x size of weld



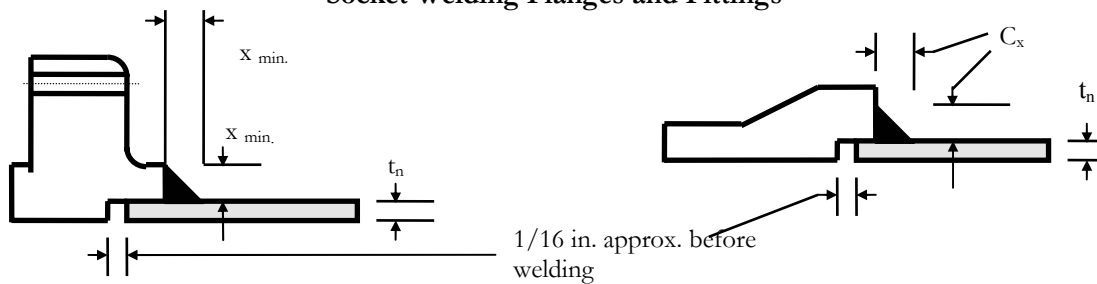
The size of an unequal leg fillet weld is the shorter leg length of the largest right triangle which can be inscribed within the fillet weld cross section.

Skewed T Joints



¹When the intersecting member is less than 60 degrees, the weld shall be considered a partial penetration groove weld.

Socket Welding Flanges and Fittings



$x_{min.} = 1.4 t_n$ or the thickness of the hub, whichever is smaller, but not less than 1/8 in.
 t_n = nominal pipe wall thickness. $C_x = 1.09 t_n$